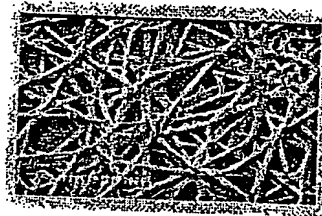


275°F



300°F



325°F  
over-bonding

